

DART AEROSPACE LTD		Work Order: 22700
Description: Dual Disabling Kit (Medium Bell)		Part Number: D412-738-041
		Keyed: <input type="checkbox"/> Alike <input checked="" type="checkbox"/> Unalike
Dwg: D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1		Qty: 34 Page 1 of 3

Step	Location	Procedure	By	Date	Qty																								
1	DC	Issue Traveler	UA	05-03-14	88																								
2	DC	Photocopy bluefile and create labels per PPP D412-738-011 CHG001	N/A	05-03-14	88																								
3	GA	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2728-7</td><td>Decal</td><td>M15464</td></tr><tr><td>1</td><td>D3373-1B 22157</td><td>Cam Lock</td><td>B22148</td></tr><tr><td>1</td><td>D3393-1</td><td>Battery Lock Casing</td><td>B22293</td></tr><tr><td>1</td><td>D3393-3</td><td>Cam Lock Shaft</td><td>B22479</td></tr><tr><td></td><td></td><td></td><td>B22556</td></tr></table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal	M15464	1	D3373-1B 22157	Cam Lock	B22148	1	D3393-1	Battery Lock Casing	B22293	1	D3393-3	Cam Lock Shaft	B22479				B22556	SB	05/03/14	34
Qty	Part Number	Description	Batch																										
1	D2728-7	Decal	M15464																										
1	D3373-1B 22157	Cam Lock	B22148																										
1	D3393-1	Battery Lock Casing	B22293																										
1	D3393-3	Cam Lock Shaft	B22479																										
			B22556																										
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.	SB	05/03/14	34																								
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5	SB	05/03/15	34																								
6	GA	Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3369-5</td><td>Washer</td><td>R22710</td></tr><tr><td>2</td><td>5/16WC</td><td>SS Flat Washer</td><td>M15715</td></tr><tr><td>A/R</td><td>N/A</td><td>262 Locktite</td><td>M16517</td></tr></table> Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key Number on page 3	Qty	Part Number	Description	Batch	1	D3369-5	Washer	R22710	2	5/16WC	SS Flat Washer	M15715	A/R	N/A	262 Locktite	M16517	SB	05/03/15	34								
Qty	Part Number	Description	Batch																										
1	D3369-5	Washer	R22710																										
2	5/16WC	SS Flat Washer	M15715																										
A/R	N/A	262 Locktite	M16517																										
7	WS	Tack Weld lock shaft to flat cam Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>SS Rod</td><td>U/A</td></tr></table>	Qty	Part Number	Description	Batch	A/R	N/A	SS Rod	U/A	PD	05-03-15	34																
Qty	Part Number	Description	Batch																										
A/R	N/A	SS Rod	U/A																										
8	GA	Apply crazy glue to caps then press caps into body. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>9567K21</td><td>Polyethelene Cap</td><td>M16964</td></tr><tr><td>A/R</td><td>N/A</td><td>Krazy Glue</td><td>M17089</td></tr></table>	Qty	Part Number	Description	Batch	2	9567K21	Polyethelene Cap	M16964	A/R	N/A	Krazy Glue	M17089	SB	05/03/17	34												
Qty	Part Number	Description	Batch																										
2	9567K21	Polyethelene Cap	M16964																										
A/R	N/A	Krazy Glue	M17089																										
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3; Mask Dowel Pins Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3368-1</td><td>Pedal Lock Base</td><td></td></tr><tr><td>1</td><td>D3368-3</td><td>Pedal Lock Cover</td><td></td></tr><tr><td>1</td><td>D3385-1</td><td>Hinge</td><td></td></tr></table> Identify as D3368-051	Qty	Part Number	Description	Batch	1	D3368-1	Pedal Lock Base		1	D3368-3	Pedal Lock Cover		1	D3385-1	Hinge		N/A										
Qty	Part Number	Description	Batch																										
1	D3368-1	Pedal Lock Base																											
1	D3368-3	Pedal Lock Cover																											
1	D3385-1	Hinge																											
10	QCS	Inspect Powder Coat	AB	05-03-30	34																								

DART AEROSPACE LTD		Work Order:	22710
Description: Dual Disabling Kit (Medium Bell)		Part Number:	D412-738-041 D3393-041
		Keyed:	<input type="checkbox"/> Alike <input checked="" type="checkbox"/> Unalike
Dwg: D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1		Qty:	30
		Page 2 of 3	

Step	Location	Procedure	By	Date	Qty																				
11	GA	Press dowel pins into D3368-3 pedal lock cover, then assemble hinge as per Dwg D3368. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2728-7</td><td>Decal</td><td></td></tr><tr><td>1</td><td>D3373-7</td><td>Cam Lock</td><td></td></tr><tr><td>3</td><td>238-028</td><td>Ø3/16" Dowel Pin ½" long</td><td></td></tr><tr><td>4</td><td>385-039</td><td>Flat Head Screw</td><td></td></tr></table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-7	Cam Lock		3	238-028	Ø3/16" Dowel Pin ½" long		4	385-039	Flat Head Screw				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3373-7	Cam Lock																							
3	238-028	Ø3/16" Dowel Pin ½" long																							
4	385-039	Flat Head Screw																							
12	GA	Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.																							
13	GA	Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-5																							
14	GA	Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>262 Locktite</td><td></td></tr></table>	Qty	Part Number	Description	Batch	A/R	N/A	262 Locktite																
Qty	Part Number	Description	Batch																						
A/R	N/A	262 Locktite																							
15	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3384-1</td><td>Cyclic Sock</td><td></td></tr><tr><td>2</td><td>CBL-460</td><td>Loop Sleeve</td><td></td></tr><tr><td>28"</td><td>CBL-1240</td><td>Cable</td><td></td></tr></table> Identify as D3384-047	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock		2	CBL-460	Loop Sleeve		28"	CBL-1240	Cable								
Qty	Part Number	Description	Batch																						
1	D3384-1	Cyclic Sock																							
2	CBL-460	Loop Sleeve																							
28"	CBL-1240	Cable																							
16	GA	Assemble D3384-047 to D3368-051 using ¼"-20 socket head cap screw and washer as per Dwg D3368. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN960-416</td><td>Washer</td><td></td></tr><tr><td>1</td><td>HX-81</td><td>¼"-20 SHCS 3/8" long</td><td></td></tr></table> Identify as D3368-041 & attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	2	AN960-416	Washer		1	HX-81	¼"-20 SHCS 3/8" long												
Qty	Part Number	Description	Batch																						
2	AN960-416	Washer																							
1	HX-81	¼"-20 SHCS 3/8" long																							
17	QC5	Inspect work to Step 16																							
18	PK	Ensure that keys are attached to D3368-041 and D3393-041 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3368-041</td><td>Pedal Lock Assembly</td><td></td></tr><tr><td>1</td><td>D3393-041</td><td>Battery Lock Assembly</td><td>B22710</td></tr></table> Ensure that keys can be locked and unlocked for each D3368-041 and D3393-041 assembly.	Qty	Part Number	Description	Batch	1	D3368-041	Pedal Lock Assembly		1	D3393-041	Battery Lock Assembly	B22710											
Qty	Part Number	Description	Batch																						
1	D3368-041	Pedal Lock Assembly																							
1	D3393-041	Battery Lock Assembly	B22710																						
19	QC4	Inspect Kit 100% for Completeness on the W/O																							
20	PK	Identify and pack for shipping as per PPP D412-738-041 + Stock																							
21	AC	Cost / part: 11.00																							
22	DC	Close W/O 11.25 Inspect Level 21																							

DART AEROSPACE LTD	Work Order: 12710
Description: Dual Disabling Kit (Medium Bell)	Part Number: D412-738-011
Dwg: D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1	Keyed: <input type="checkbox"/> Alike <input checked="" type="checkbox"/> Unalike Qty: 33 Page 3 of 3

D3368-041 Key Numbers	D3393-041 Key Numbers
	C579A ✓
	C363A ✓
	C181A ✓
	C057A ✓
	C590A ✓
	C061A ✓
	C076A ✓
	C162A ✓
	C576A ✓
	C574A ✓
	C587A ✓
	C316A ✓
	C079A ✓
	C094A ✓
	C573A ✓
	C091A ✓
	C086A ✓
	C418A ✓
	C572A ✓
	C525A ✓
	C139A ✓
	C440A ✓
	C104A ✓
	C177A ✓
	C415A ✓
	C014A ✓
	C103A ✓
	C144A ✓
	C554A ✓
	C403A ✓
	C087A ✓
	C201A ✓
	C581A ✓
	C372A ✓
	C148A

Rev	Date	Change	Revised By	Approved
A	05.02.01	New Issue	KJ/JLM	
B	05.02.18	Revised procedures	KJ/JLM	
C	05.02.24	Revised Steps 6, 8 & 14	KJ/JLM	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 14, 2005
08:30 am

Work Order No : 0022710
Project Name : D3393-041
Project For : WK511
Work Order Type : Main
Main WO Number :
House Part Number : D3393-041
Description : Battery Lock Assembly
Manufactured : Yes
Amount Req'd : 38
Amount Done : 0
Start Date : 03-14-05
Est Finish Date : 03-18-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00